

Work Order ID 119097

Thursday, May 08, 2014 11:41:57 AM

119097

Page 1

Item ID: D206-559-033

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Wearplate

Start Date: 5/8/2014 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 5/22/2014 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: CMF Date: 14-5-8

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-559	REV L

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels per PPP D206-559-033 CHG 003 CEDAS
28
9-89

MAY 14 2014

105

Pick Kit

0.00

105

Packaging

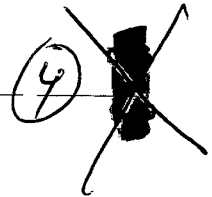
Memo

0.00

Packaging

DAS
32
9-89

14/5/9



110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS
28
9-89

MAY 14 2014

DAS
06
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 119097

Thursday, May 08, 2014 11:41:58 AM

119097

Page 2

Item ID: D206-559-033

Revision ID:

Item Name: Bearpaw Wearplate

Start Date: 5/8/2014 Start Qty: 4.00

Required Date: 5/22/2014 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D206-559-033

Location:

PPP Rev:

128

0.00

0.00

4

DAS
06
9-89

MAY 14 2014

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Give to Linda.
to make a comment.

14/5/15

14-5-14

DQA: _____

Date: _____



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐

Scrap ☐

Use-as-is ☐

Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐

Machining ☐

Thermoforming ☐

Large Fab ☐

Crosstube ☐

Small Fab ☐

Finishing ☐

Composite ☐

Water Jet ☐

Prod. Eng. Coord. ☐

Rec/Store/Packaging ☐

Supplier ☐

Engineering ☐

Quality ☐

Other ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear

☐ Bending

☐ Centre Not Concentric

☐ Cracks

☐ Crimp/Kink/Ripple/Wave

☐ Cuffs

☐ Crushing

☐ Heat Treat

☐ Inspection Strip in Tube

☐ Marks/Chatter

☐ Turning Sequence

☐ Wave/Twist in Tube

General

☐ Bend

☐ BOM/Route

☐ Broken/Damage/Defect

☐ Burrs

☐ Contamination

☐ Countersink

☐ Cut Too Short

☐ Drawing

☐ Drill Holes

☐ Finish

☐ Fit/Function

Folio/Program

☐ Grain

☐ Hardware

☐ Inspection Incomplete/Unqualified

☐ Instructions Incomplete/Unclear

☐ Misaligned/off center

☐ Mislabeled

☐ Misread

☐ Off-set

☐ Out of Calibration

☐ Out of Sequence

☐ Outside Dimensions

☐ Over/Under tolerance

☐ Part Incorrect

☐ Part Lost/Missing

☐ Part Moved

☐ Positioned Wrong

☐ Power Loss/Surge

☐ Pressure/Forced

☐ Set-up

☐ Temperature/Cure

☐ Weld

☐ Wrong Stock Pulled

☐ Other

Picklist Print

Thursday, May 08, 2014 11:41:56 AM

Page 2

Work Order ID: 119097

119097

Parent Item: D206-559-033

D206-559-033

Parent Item Name: Bearpaw Wearplate

Start Date: 5/8/2014

Required Date: 5/22/2014

Start Qty: 4.00

Required Qty: 4.00

D3859-041

Manufactured No

Each 10.0000

**** 2 8**

DAS
32
9-89

D3859-041

Wearplate

DAS
28
9-89

Location

Loc Qty

Loc Code

ST257

10

110015

4

113258

2

117716

4

110015 CP
113258 2P

MS21042L4

Purchased No

Each 7,114.000

**** 12 48**

DAS
32
9-89

MS21042L4

Locknut

DAS
28
9-89

Location

Loc Qty

Loc Code

ST314

44

m126015

12

m126275

32

ST509

7059

m127255

71

m127813

988

m128300

1000

m128798

5000

ST518

11

m127376

11

m128300

NAS1149D0463J

Purchased No

Each 6,700.000

**** 12 48**

DAS
32
9-89

NAS1149D0463J

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST510a

6700

M126221

20

M127813

22

M127904

3000

M128591

2158

M128995

1500

m128091

Thursday, May 08, 2014 11:41:57 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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REFERENCE ONLY

reference only

DART AEROSPACE LTD.

**DAS
28
9-89**

D206-559
Page 7 of 13

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Revision: L
Date: 11.04.08

Work Order ID 119097

Thursday, May 08, 2014 11:41:57 AM

119097

Page 1

Item ID: D206-559-033

Revision ID:

Item Name: Bearpaw Wearplate

Start Date: 5/8/2014 Start Qty: 4.00

Required Date: 5/22/2014 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: ME

Date: 14-5-8

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-559	REV L								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels per PPP D206-559-033	CHG 003							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

ML5 14-05-09

